- 1 We claim:
- 1. A method to isolate *d-threo*-methylphenidate in greater than 99 percent
- 2 enantiomeric excess from a mixture of *d-threo*-methylphenidate and *l-threo*-methylphenidate,
- 3 comprising the steps of:
- 4 providing a mixture comprising *d-threo*-methylphenidate and *l-threo*-methylphenidate;
- 5 supplying *l*-fenchyloxyacetic acid;
- 6 treating said mixture with said *l*-fenchyloxyacetic acid;
- 7 collecting *d-threo*-methylphenidate having greater than a 99 percent enantiomeric excess.
- 1 2. The method of claim 1, wherein said supplying step further comprises the steps
- 2 of:
- 3 providing *l*-fenchyl alcohol;
- 4 providing chloroacetic acid;
- 5 reacting said *l*-fenchyl alcohol with said chloroacetic acid to form said *l*-fenchyloxyacetic
- 6 acid.
- 1 3. The method of claim 1, wherein said treating step includes the following steps:
- 2 reacting said mixture with said *l*-fenchyloxyacetic acid;
- isolating the salt of (1R)-endo-(+)-fenchyloxyacetic acid and *d-threo*-methylphenidate;
- 4 and
- 5 cracking said salt of (1R)-endo-(+)-fenchyloxyacetic acid and *d-threo*-methylphenidate.
- 1 4. The method of claim 3, wherein said cracking step includes the following steps:
- 2 providing a 10 percent solution of sodium bicarbonate in water;

3	treating the sal	t of (1R)-end	do-(+)-fenchyloxya	acetic acid and d-th	reo-methylphenidate
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- 4 with said aqueous sodium bicarbonate solution and ethyl acetate to give a two phase mixture
- 5 comprising a water fraction and an ethyl acetate fraction;
- 6 separating the ethyl acetate fraction from said water fraction; and
- 7 treating said ethyl acetate fraction with hydrochloric acid.
- 1 5. The method of claim 4, further comprising the steps of:
- 2 obtaining *l-threo*-methylphenidate from said water fraction;
- 3 hydrolyzing said *l-threo-*methylphenidate to 1-ritalinic acid;
- 4 reacting said 1-ritalinic acid with a methanol solution saturated with hydrogen chloride to
- 5 form *dl*-methylphenidate.
- 1 6. A method to isolate *d-threo*-methylphenidate in greater than 99 percent
- 2 enantiomeric excess from a racemic mixture of d-threo-methylphenidate and l-threo-
- 3 methylphenidate, comprising the steps of:
- 4 providing a racemic mixture comprising *d-threo-*methylphenidate and *l-threo-*
- 5 methylphenidate;
- 6 obtaining a second mixture of *d-threo-*methylphenidate and *l-threo-*methylphenidate from
- 7 said racemic mixture, wherein said second mixture comprises d-threo-methylphenidate having
- 8 greater than a 90 percent enantiomeric excess;
- 9 supplying *l*-fenchyloxyacetic acid;
- treating said second mixture with said *l*-fenchyloxyacetic acid;
- 11 collecting *d-threo-*methylphenidate having greater than a 99 percent enantiomeric excess.
- 1 7. The method of claim 6, wherein said obtaining step includes passing said racemic
- 2 mixture through a chiral column chromatograph.

- 1 8. The method of claim 6, wherein said obtaining step includes the steps of:
- 2 reacting said racemic mixture with an optically active acid in methanol to give insoluble
- 3 solids and a methanolic solution:
- 4 separating said insoluble solids and said methanolic solution;
- 5 adding water to said methanolic solution;
- 6 filtering said water / methanol solution to collect said second mixture.
- 1 9. The method of claim 8, wherein said treating step includes:
- 2 reacting said second mixture with said *l*-fenchyloxyacetic acid;
- isolating the salt of (1R)-endo-(+)-fenchyloxyacetic acid and *d-threo*-methylphenidate;
- 4 and
- 5 cracking said salt of (1R)-endo-(+)-fenchyloxyacetic acid and *d-threo*-methylphenidate.
- 1 10. The method of claim 9, wherein said cracking step includes the following steps:
- 2 providing a 10 percent solution of sodium bicarbonate in water;
- 3 treating the salt of (1R)-endo-(+)-fenchyloxyacetic acid and d-threo-methylphenidate
- 4 with said aqueous sodium bicarbonate solution and ethyl acetate to give a two phase mixture
- 5 comprising a water fraction and an ethyl acetate fraction;
- 6 separating the ethyl acetate fraction from said water fraction; and
- 7 treating said ethyl acetate fraction with hydrochloric acid.
- 1 11. The method of claim 8, wherein said insoluble solids comprises the adduct of l-
- 2 threo-methylphenidate and said optically active-acid, further comprising the steps of:
- forming 1-ritalinic acid from said insoluble solids:
- 4 providing a saturated solution of hydrogen chloride in methanol;
- 5 esterifying said 1-ritalinic acid using said saturated solution to form said racemic mixture.

12. A method to resolve stereoisomers of an optically active compound comprising an amine moiety, comprising the steps of:

providing a mixture comprising two stereoisomers of a compound comprising a amine moiety;

moiety;

supplying *l*-fenchyloxyacetic acid;

treating said mixture with said *l*-fenchyloxyacetic acid;

collecting one of said two or more stereoisomers having greater than a 99 percent

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13

enantiomeric excess.